Application No. 10/079,293

cutting the cylindrical body from the cylindrical work piece such that the outer surface of the cylindrical body is cut tangent to the outer surface of the cylindrical work piece.

2. A method as recited in claim 1 further comprising the step of cutting a second cylindrical body from the cylindrical work piece wherein the outer surface of the second cylindrical body is cut tangent to the outer surface of the cylindrical work piece.

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3. A method as recited in claim 2 wherein the step of cutting a second cylindrical body comprises the step of cutting a second cylindrical body tangent to the first cylindrical body at the central axis of the work piece.

4. A method for forming a cylindrical cutting element body of a predetermined diameter having a canted end surface, the method comprising the steps of:

forming a cylindrical work piece having a cylindrical outer surface and a longitudinal central axis and a diameter at least twice the predetermined diameter and a convex protrusion extending from an end of the cylindrical work piece; and

cutting the cylindrical body from the cylindrical work piece, wherein cylindrical body comprises a longitudinal central axis the central axis, wherein the longitudinal central axis of the workpiece is offset from the longitudinal central axis of the cylindrical body.

5. A method as recited in claim 4 further comprising the step of cutting a second cylindrical body from the cylindrical work piece wherein the second cylindrical body comprises a longitudinal central axis offset from the longitudinal central axis of the work piece.

Application No. 10/079,293

6. A method as recited in claim 5 wherein the step of cutting a second cylindrical body comprises the step of cutting a second cylindrical body tangent to the first cylindrical body at the central axis of the work piece.

7. A method as recited in claim 4 wherein the step of cutting the first cylindrical body comprises the step of cutting the first cylindrical body having a cylindrical outer surface tangent to the outer cylindrical outer surface of the workpiece.

91 8. A method as recited in claim 7 further comprising the step of cutting a second cylindrical body from the cylindrical work piece, wherein the second cylindrical body comprises a longitudinal central axis offset from the central longitudinal axis of the workpiece and wherein the second cylindrical body outer surface is tangent to workpiece cylindrical outer surface.

Sub B1 ~~9. (New) A cutting element comprising:~~

a hard material body having an end surface and a periphery defining a circumference, the end surface comprising a canted portion extending to the periphery and an uncanted portion extending to the periphery, wherein the canted portion intersects the periphery along a periphery line, and wherein the periphery line continuously extends around more than half of the periphery circumference; and

92 an ultra hard material layer formed over the end surface having an exposed upper surface.

10. (New) A cutting element as recited in claim 9 wherein the entire periphery line extends along a plane.

11. (New) A cutting element as recited in claim 9 wherein the ~~canted portion~~ comprises a non-planar portion.

Application No. 10/079,293

Subb1 ~~12. (New) A cutting element as recited in claim 9 wherein the~~ periphery line is non-linear.

13. (New) A cutting element as recited in claim 9 wherein the uncanted portion is non-planar.

14. (New) A cutting element as recited in claim 13 wherein the uncanted portion comprises a non-planar portion.

15. (New) A cutting element as recited in claim 9 wherein the ultra hard material layer comprises an exposed upper surface.

16. (New) A cutting element comprising:

a hard material body having an end surface bounded by a periphery defining a circumference, the end surface comprising, a non-planar portion, a canted portion extending to the periphery, and an uncanted portion extending to the periphery, wherein the canted portion comprises a non-planar portion, wherein the canted portion intersects the periphery along a periphery line; and

Q2 an ultra hard material layer formed over the end surface.

17. (New) A cutting element as recited in claim 16 wherein the periphery line continuously extends around more than half of the periphery circumference.

18. (New) A cutting element as recited in claim 16 wherein the entire periphery line extends along a plane.

19. (New) A cutting element as recited in claim 16 wherein the periphery line is non-linear.